

Date: Thursday, 7/5/2007 8:15:55 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : LUG EXTRUSION
 Job Number : 33310
 Estimate Number : 10305
 P.O. Number : N/A Part Number : D2423
 This Issue : 7/5/2007 S.O. No. : N/A Drawing Number : D2423 REV B1
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : PURCHASED PARTS Drawing Revision : B1
 Previous Run : 30062 Material : N/A
 Due Date : 8/12/2007 Qty: 360 Um: Each
 Written By :
 Checked & Approved By : AD 07.07.05
 Comment : Est G 04.09.02 Part Number D2423-108 changed to D2423 K
 J/JLM

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING
2.0	D2423P	Lug Extrusion
Comment: Qty.: 1.0000 f(s)/Unit Total : 360.0000 f(s) Lug Extrusion		
3.0	PACKAGING 1	PACKAGING RESOURCE #1
4.0	QC6	DIMENSIONAL CHECK
5.0	PACKAGING 1	PACKAGING RESOURCE #1
6.0	QC21	FINAL INSPECTION/W/O RELEASE
Comment: FINAL INSPECTION/W/O RELEASE		
Job Completion		



P/O: 4104 C207107105 (360FT)
 C271119 3088 2360
 20723 5497
 (checked/measured)



C207108110

62

Nm 07/09/25

I.D and stock material.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 07/01/10
 QA: N/C Closed: _____ Date: _____

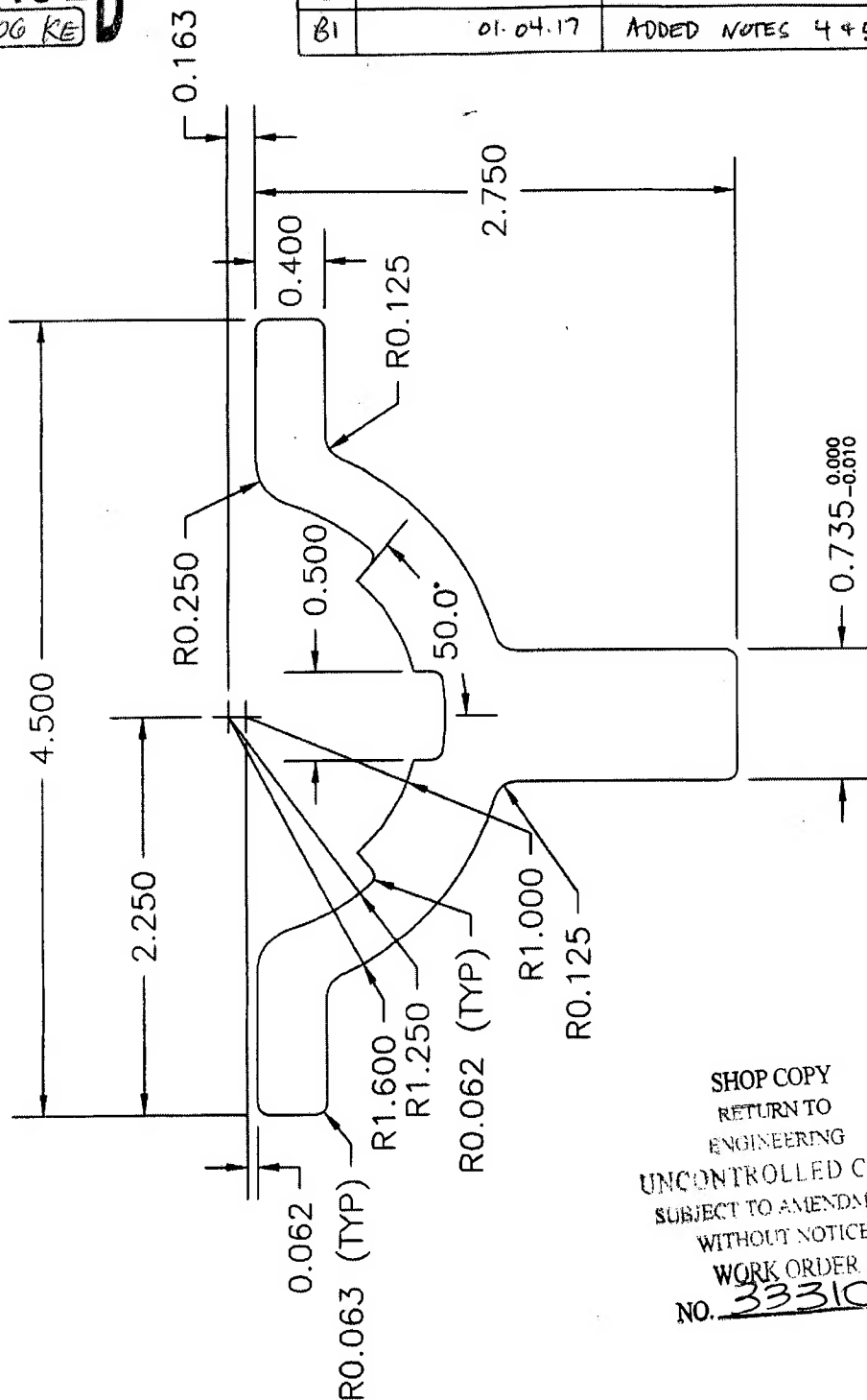
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2423	REV. B SHEET 1 OF 1
DATE 98.08.04		TITLE LUG EXTRUSION	SCALE 1:1
A	95.05.09	NEW ISSUE	
B	98.08.04	6061-T6 WAS 6005A.T5	
B1	01.04.17	ADDED NOTES 4 & 5 <i>CP</i>	

RELEASED
98/08/06 KE



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 33310

1. MATERIAL: 6061-T6 ALUMINUM (QQ-A-200/8)
2. NOTE: ALL DIMENSIONS ARE IN INCHES
3. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4. MANUFACTURED USING CARBIDE INDEX DIE # MS-18866
5. PART NUMBER IS D2423-XXX WHERE XXX IS CUT LENGTH IN INCHES (EG. D2423-108 IS 108" LONG)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

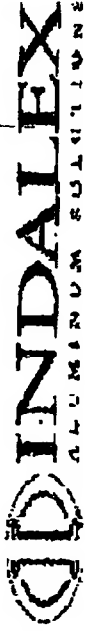
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries





325 rue Avro
Pointe-Claire QC H9R 5W3
Téléphone (514) 697-5120
Fax-simile (514) 694-8310

Rapport des propriétés mécaniques Mechanical Properties Test Report

Client / Customer : DART AEROSPACE LTD
Adresse / Address : 1270 ABERDEEN STREET
HAWKESBURY ONT;
K8A 1K7

commande Indalex / Indalex order #: 7070534
bon de commande / Purchase order #: 4104
de matrice / Die #: MS 18856 Description: LUG-EXTRUSION

Alliage & trempage / Alloy & temper: 6061 T6

Contrôle / Control #: 58592-1

Coulée / Cast #: 40861

	Min. requis Min. required	Résultat actuel Actual results
Tension ultime Ultimate stress (psi)	38 000	42729
Contrainte élastique Yield stress (psi)	35 000	40142
% élongation dans 2" % elongation in 2"	8	12
Dureté Rockwell E (HRC) Rockwell E Hardness (HRC)	88 @ 100	92

Composition chimique typique / Typical chemical composition:

	Si	Fe	Cu	Mn	Mg	Cr	Zn	P
6063	0.20 - 0.60	0.35 Max	0.10 Max	0.10 Max	0.45 - 0.90	0.10 Max	0.10 Max	0.10 Max
6005	0.60 - 0.90	0.35 Max	0.10 Max	0.10 Max	0.40 - 0.60	0.10 Max	0.10 Max	0.10 Max
6061A	0.08 - 0.72	0.15 - 0.27	0.08 - 0.12	0.20 - 0.24	0.45 - 0.52	0.03 Max	0.03 Max	0.03 Max
6061	0.40 - 0.80	0.70 Max	0.15 - 0.40	0.15 Max	0.80 - 1.20	0.04 - 0.35	0.25 Max	0.15 Max
6351	0.7 - 1.5	0.5 Max	0.10 Max	0.40 - 0.80	0.40 - 0.80	--	0.20 Max	0.20 Max

Nous certifions que le matériel fourni répondre les exigences chimiques telles qu'énoncées par la norme ASTM B-221 excepté pour la section 8.2 (nombre de spécimen) et AMS QQA 200/8 excepté pour la section 4.2.3.1 (nombre de spécimen) qui sont déterminés par les exigences du client.

We hereby certify that the material supplied meets the chemical properties as published by the ASTM B-221 except for section 8.2 (number of specimen) and AMS QQA 200/8 except for section 4.2.3.1 (number of specimen) which is determined by customer requirement.

Sincèrement vôtre,
Yours truly,

date : 2007-07-18

Mark Oliver Koklong
Technicien de la qualité
Quality technician

Indalex Limited

1	HZ	K6	CUS	20	SALES MAN	COA	ITEM NO.	PO	WEH	1	5	We here chemist Associa	18 JUL 2007 1:28 PM
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